

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022473**Date Inspected:** 05-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: Seg3013AD-067 [X4394B stiffener on Floor Beam (FB) 3193A to Side panel (SP) 3092E, complete joint penetration (CJP) weld at panel point (PP) 119+1500]. The welder is identified as 067572 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 20573 Rev-0.

Repair welding of weld joint no: Seg3013AA-116 [Deck Panel (DP) 3116A to Edge Panel (EP) 3020B, CJP weld at PP118 to PP118.35]. The welder is identified as 069683 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by

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this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per WRR: 20525 Rev-0.

Repair welding of weld joint no: Seg3013AD-003 (FB3178A to SP3092B, CJP weld at PP118). The welder is identified as 047864 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: 20534 Rev-0.

The SMAW process on weld joint no: Seg3013K-026 (SP3101A to FB3184A, CJP hold back weld at PP119-1500). The welder is identified as 067707 and was observed welding in 3G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: Seg3013-001 (DP3126A to DP7501A, CJP weld). The welder is identified as 066443 and was observed welding in 2G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

The SMAW process on weld joint no: Seg3013-012 (DP3116A to DP3117A, CJP weld). The welder is identified as 067609 and was observed welding in 4G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013F-112 [I-rib on SP3102A to RS stiffener (RS3438J), CJP weld at PP119+1500]. The welder is identified as 048433 and was observed welding in 3G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: Seg3013D-179 [web plate X4213A on SP3101A to RS stiffener (RS3440J), CJP weld at PP119.65]. The welder is identified as 048696 and was observed welding in 3G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

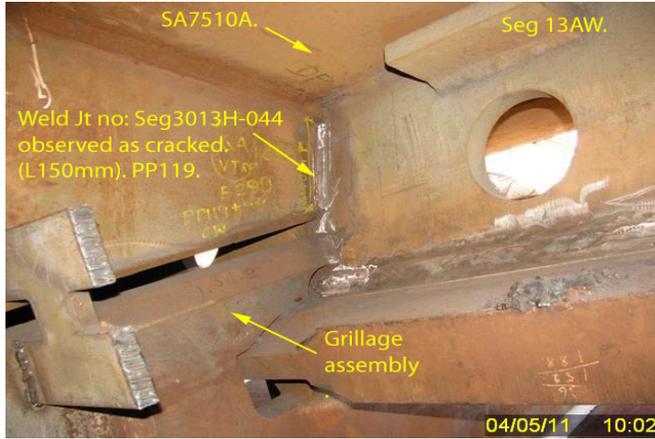
Grillage Assembly:

This QA Inspector observed that the weld jt: Seg3013H-044 [Deck Panel (DP) diaphragm of SA7510A to RS stiffener of SA7510A, CJP weld, at PP119] is cracked to its complete length (L150mm). This QA Inspector notified the ZPMC QC, identified as Shen Jian Bo. ZPMC QC agreed to make Critical Welding Report (CWR) before this weld is removed and re-welded. See attached photo for further details. This QA Inspector notified the CT Lead Inspector of this incident as documented in this report.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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